

Date: Thursday, 22/01/2009 2:05:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 45078	
Estimate Number : 10908	
P.O. Number :	Part Number : D33307
This Issue : 22/01/2009 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 44241	Material :
Written By :	Due Date : 05/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.01.22</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	
Est Rev:B Now on Waterjet 06-09-25 JLM	
est C 07.05.14 rev C dwg EC	
Est D 07.12.12 rev C dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



Comment: Qty.: 0.7971 sf(s)/Unit Total : 7.9710 sf(s)
 1010-1025 sheet .125
 Batch: 109947 IB 9-2-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3330
 Dwg Rev: D
 Prog Rev: D

HB 9-2-3

2-Deburr if necessary

HB 9-2-3

(10)

QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

505102103 (H10)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr
 Form as per Dwg D3330

SB 09/22/23

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 2:05:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 45078

Part Number: D33307

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.02.23 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

u 09.02.25

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25

Job Completion



u 09.02.25

W/O:		WORK ORDER CHANGES					
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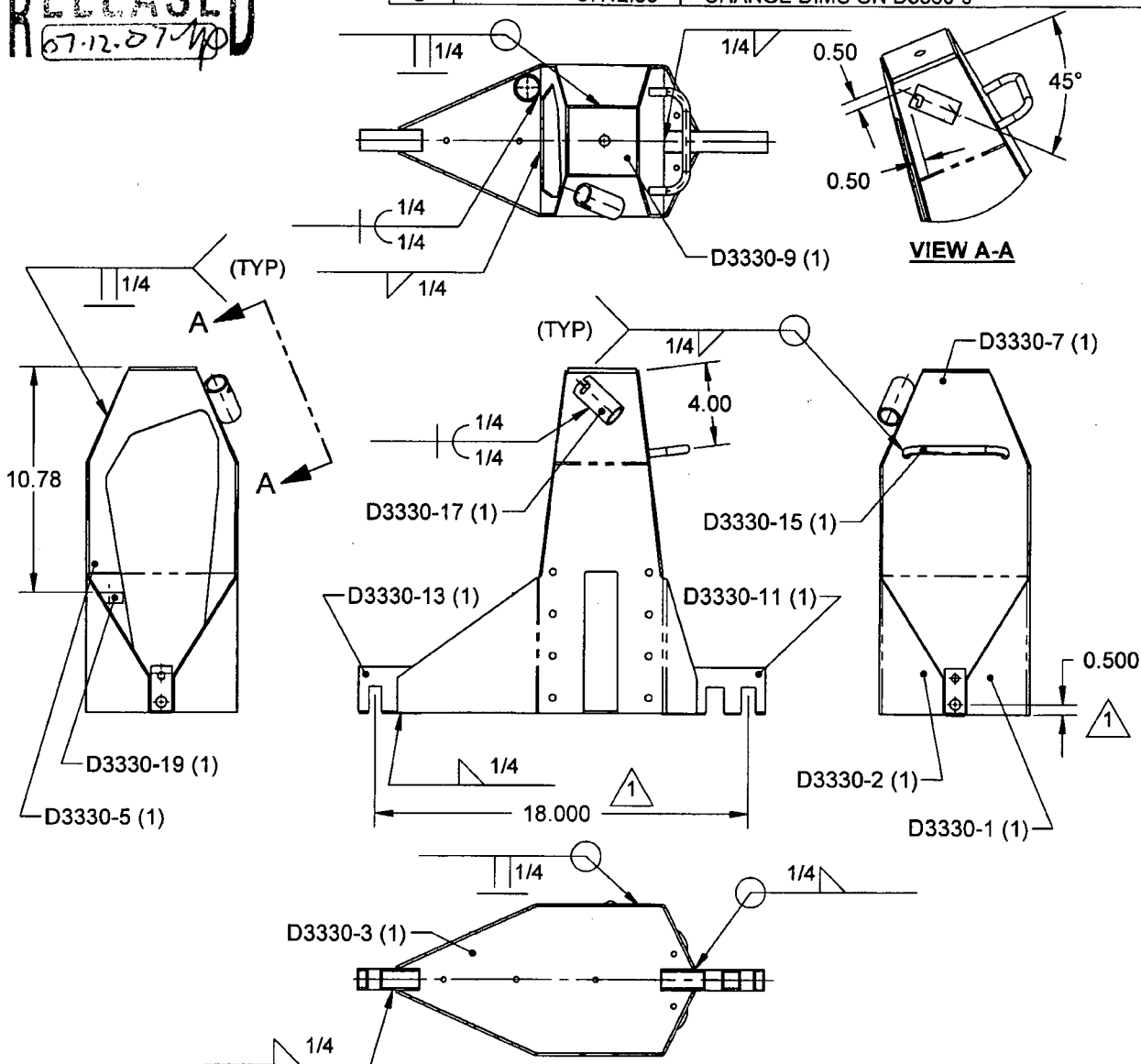
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NOTE: Date & initial all entries



DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED W	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

RELEASED
07-12-07-10



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 WORK ORDER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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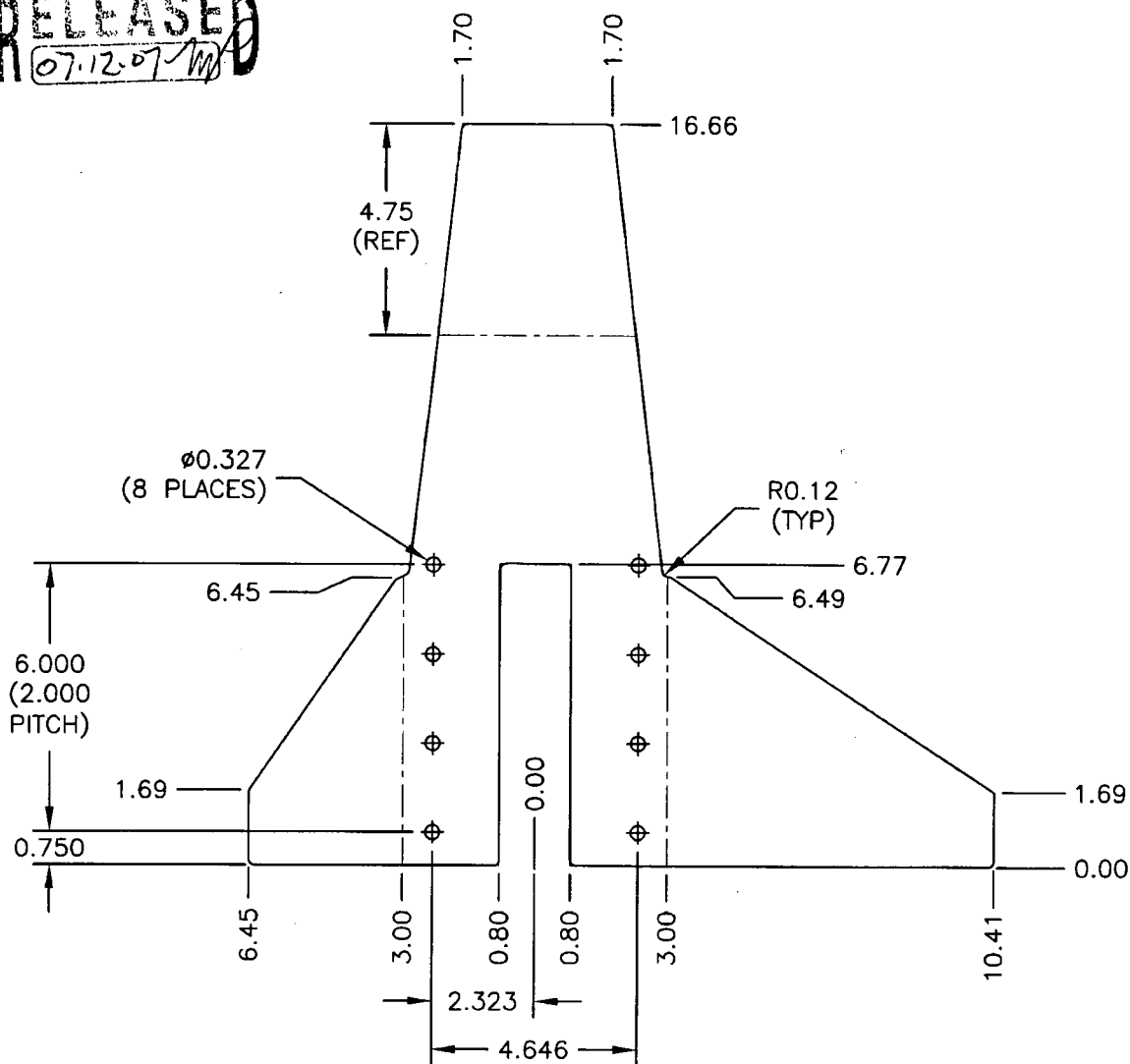
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07.12.07 *[Signature]*



D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

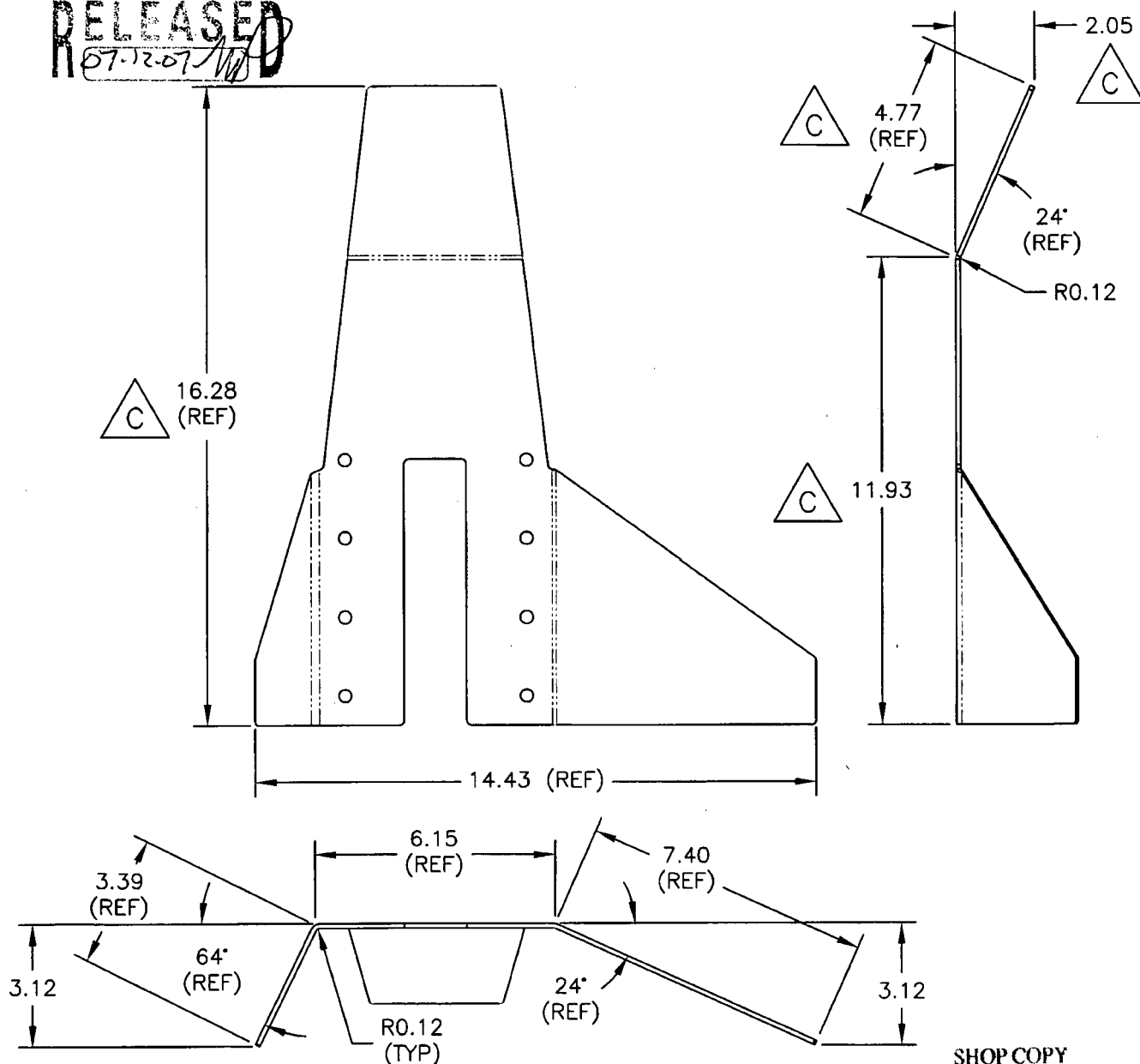
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>JB</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. D SHEET 3 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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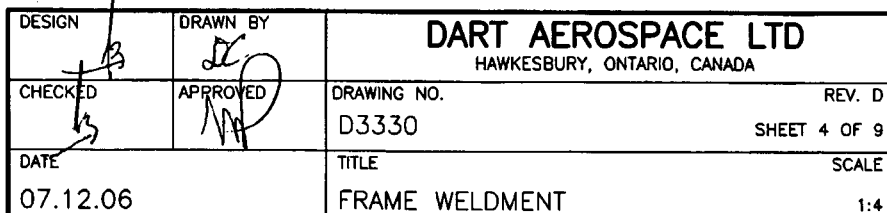
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

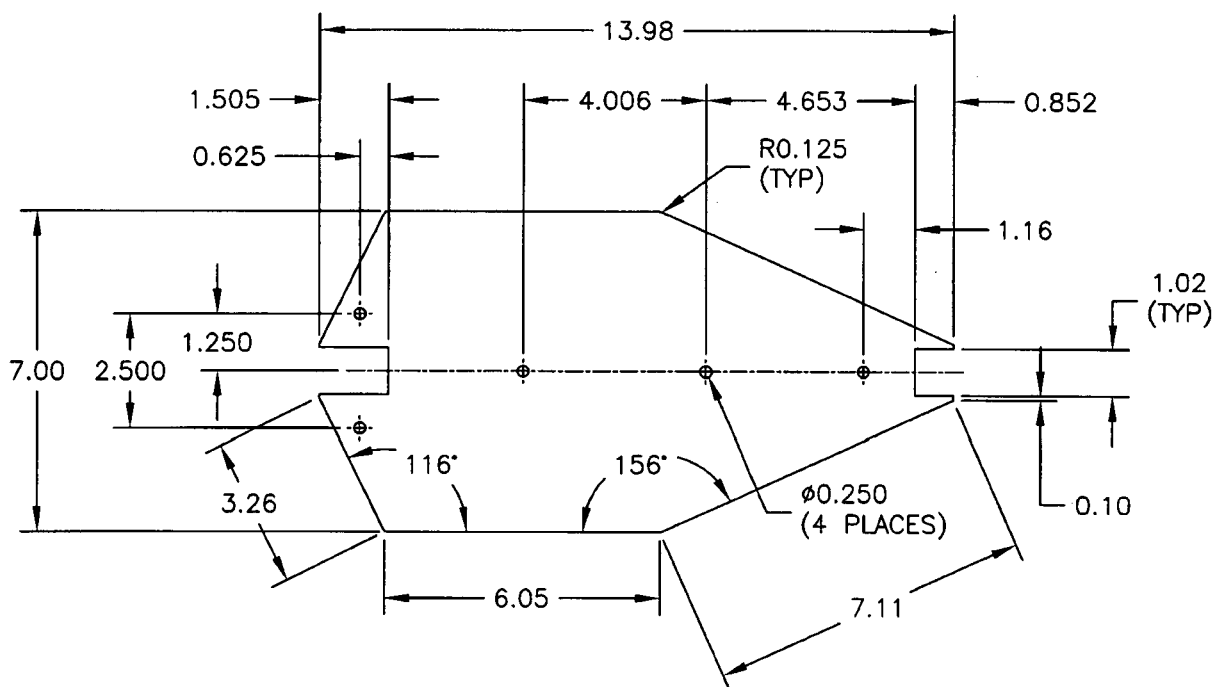
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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07-12-07



D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 TO AMENDMENT 1
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK) NOTICE
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
3) ALL DIMENSIONS ARE IN INCHES NO. 45078
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

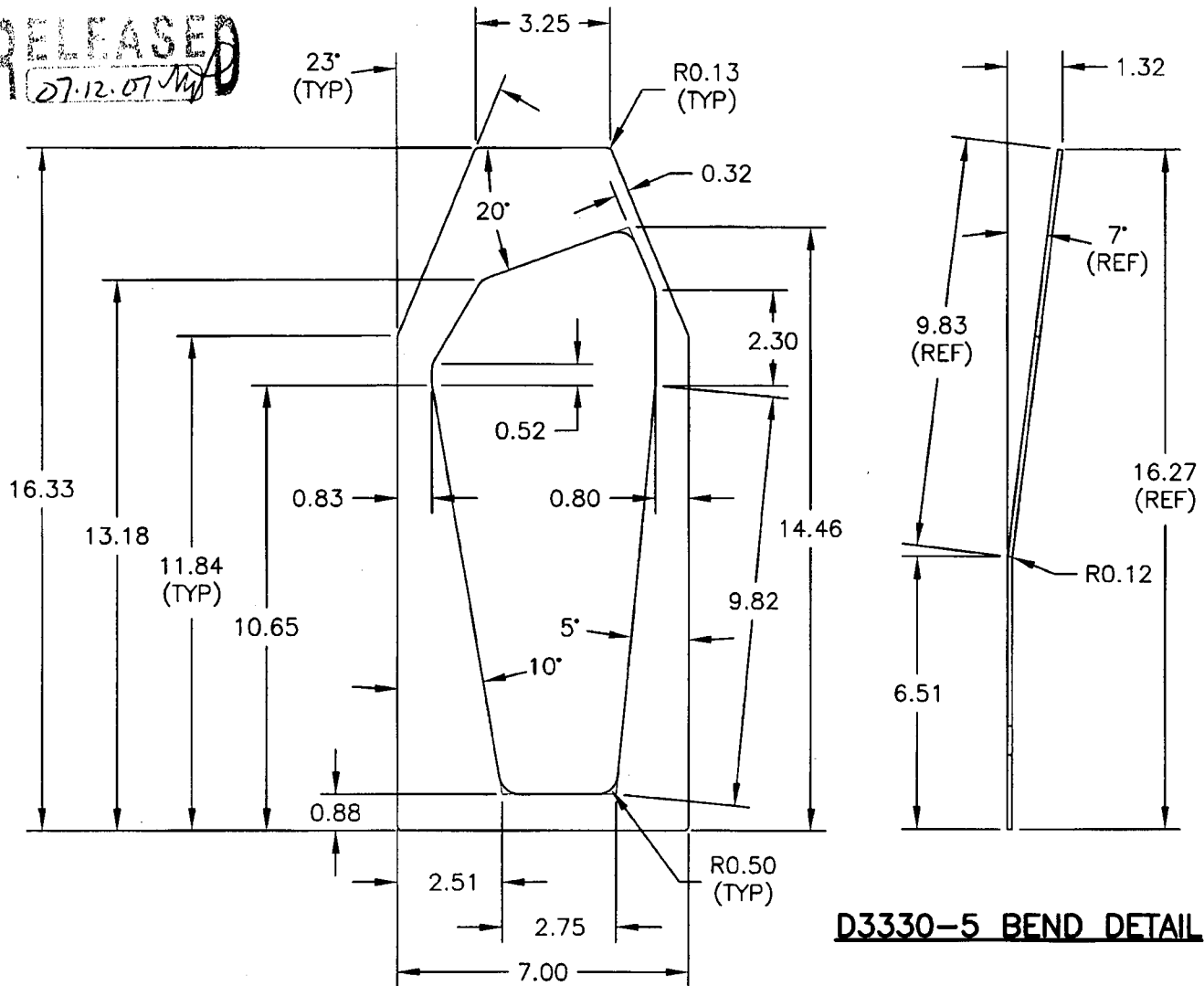
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:4

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07.12.07 *My***NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) 3000
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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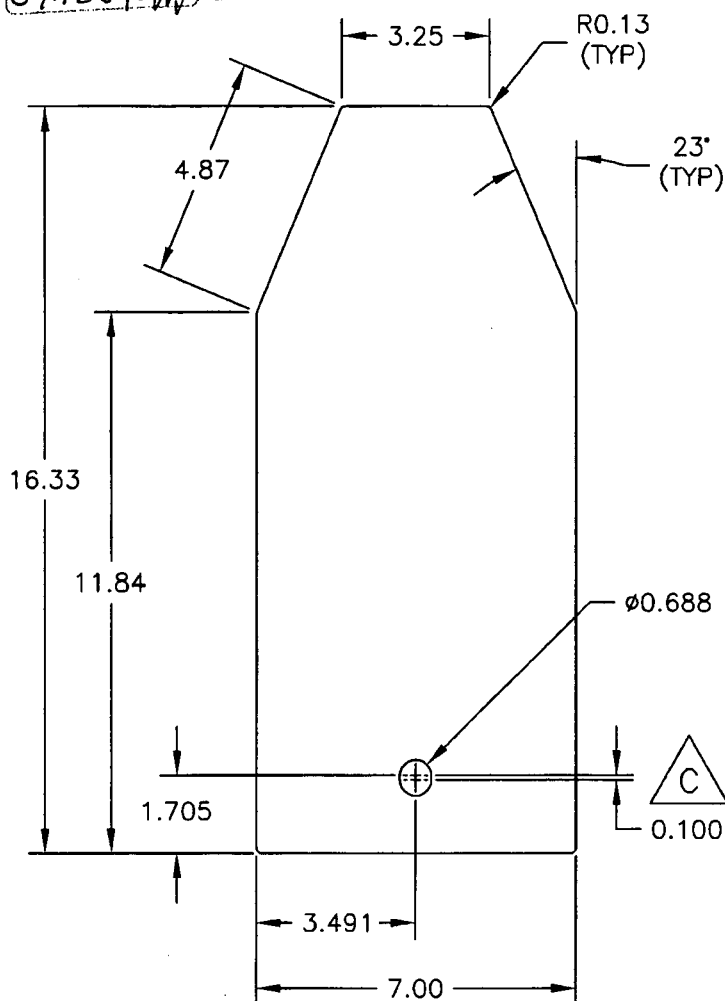
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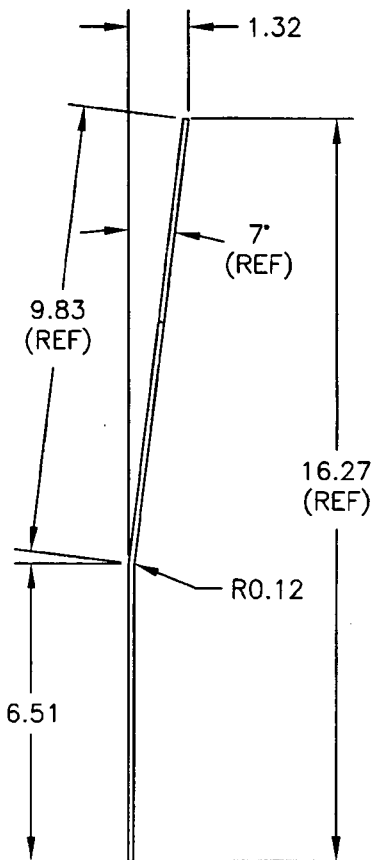


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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

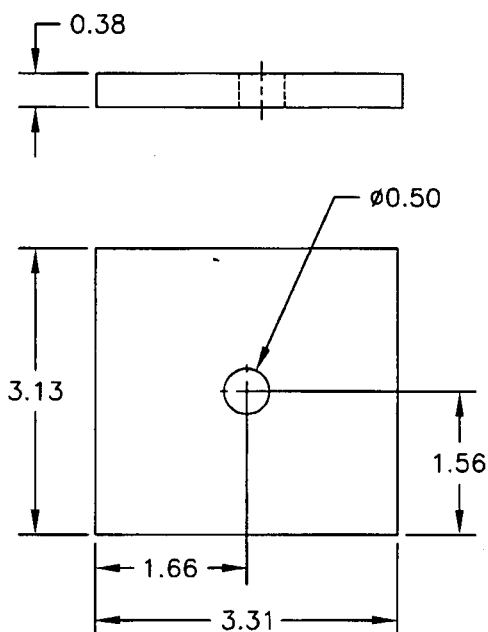
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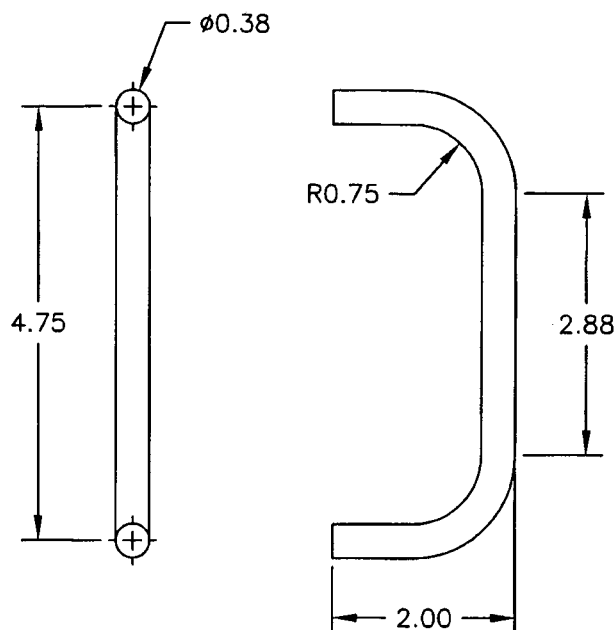


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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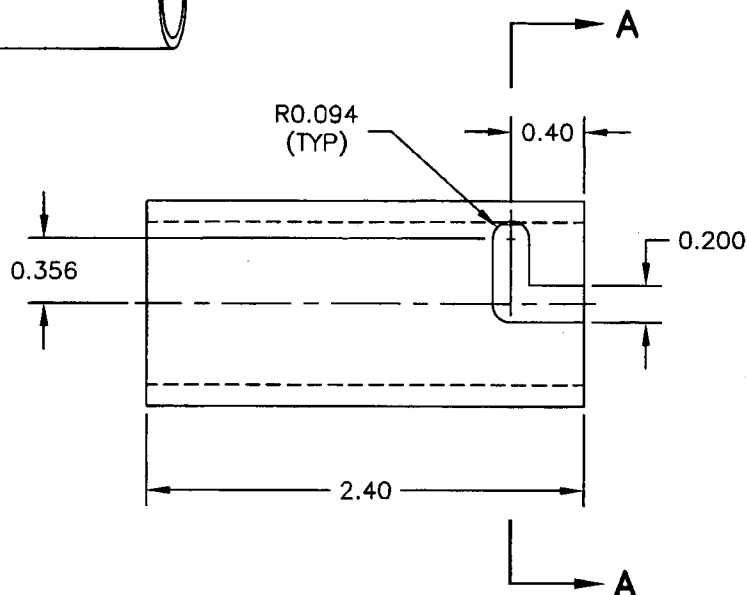
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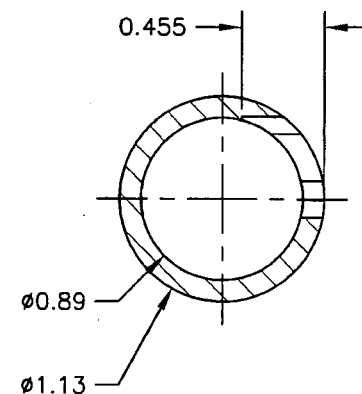
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

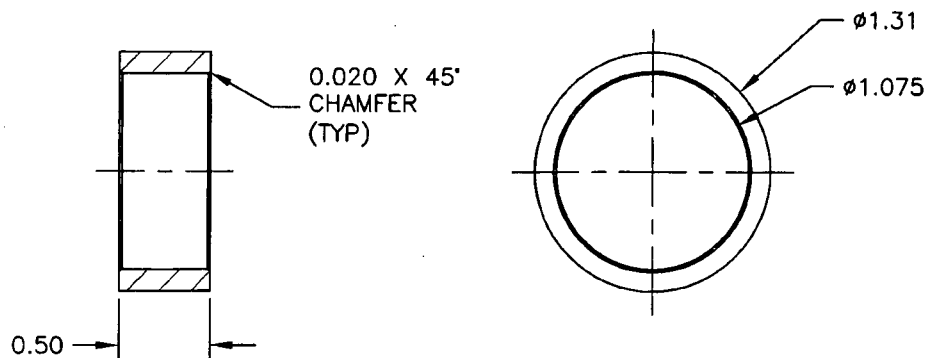


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07.12.07 *[Signature]*



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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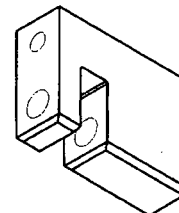
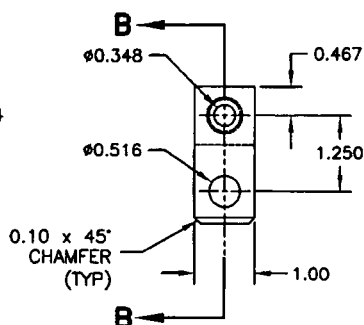
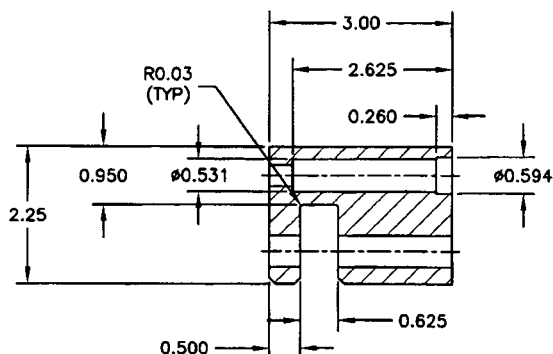
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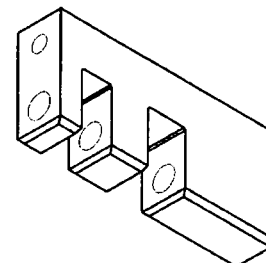
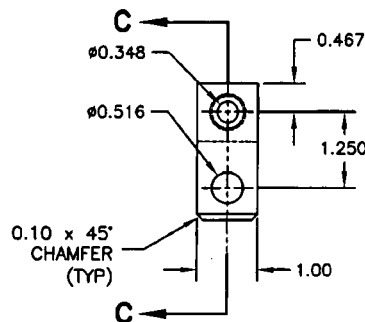
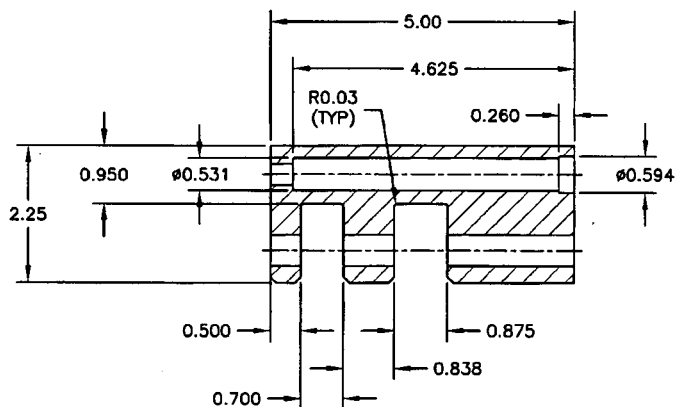
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

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07.12.07



SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
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